

FIG. 1

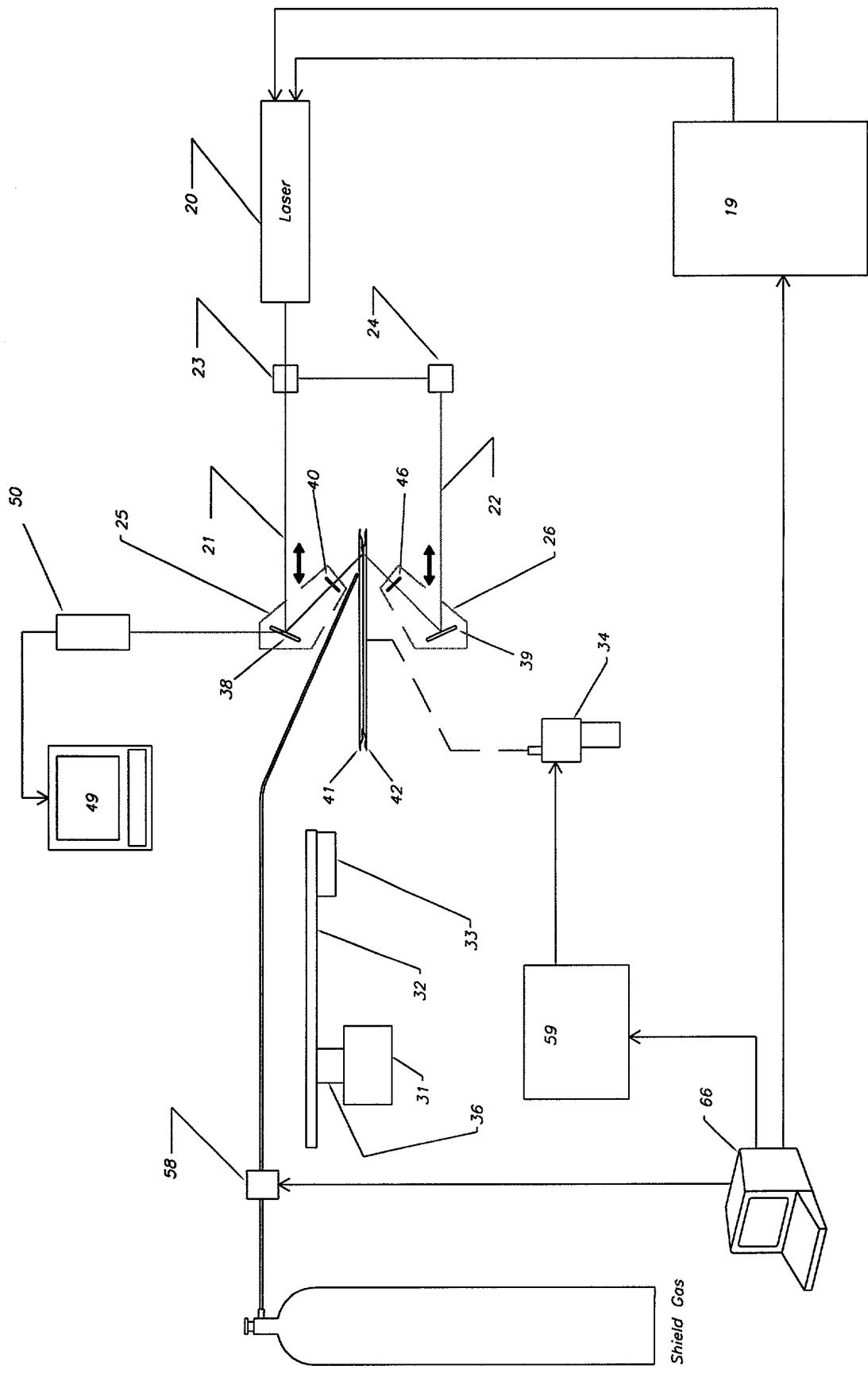


FIG 2

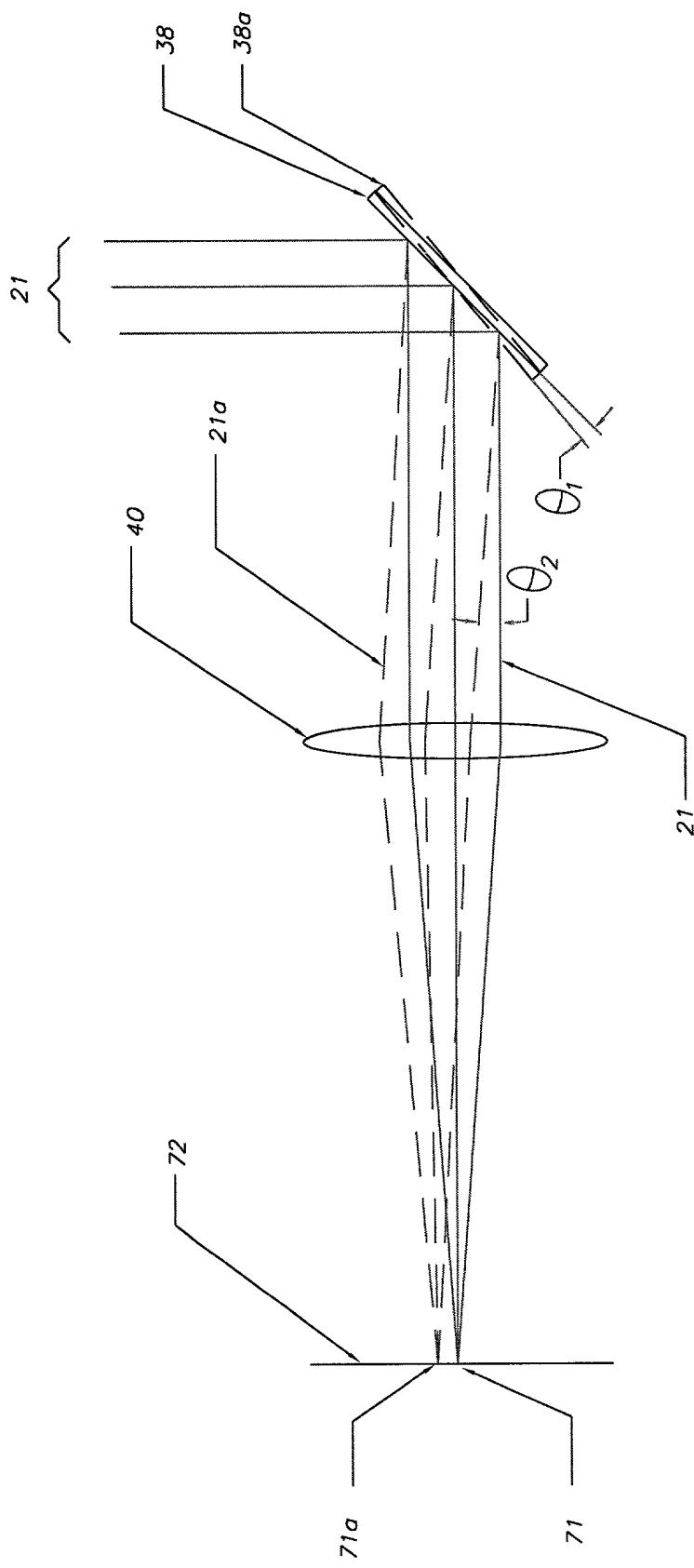


FIG 3

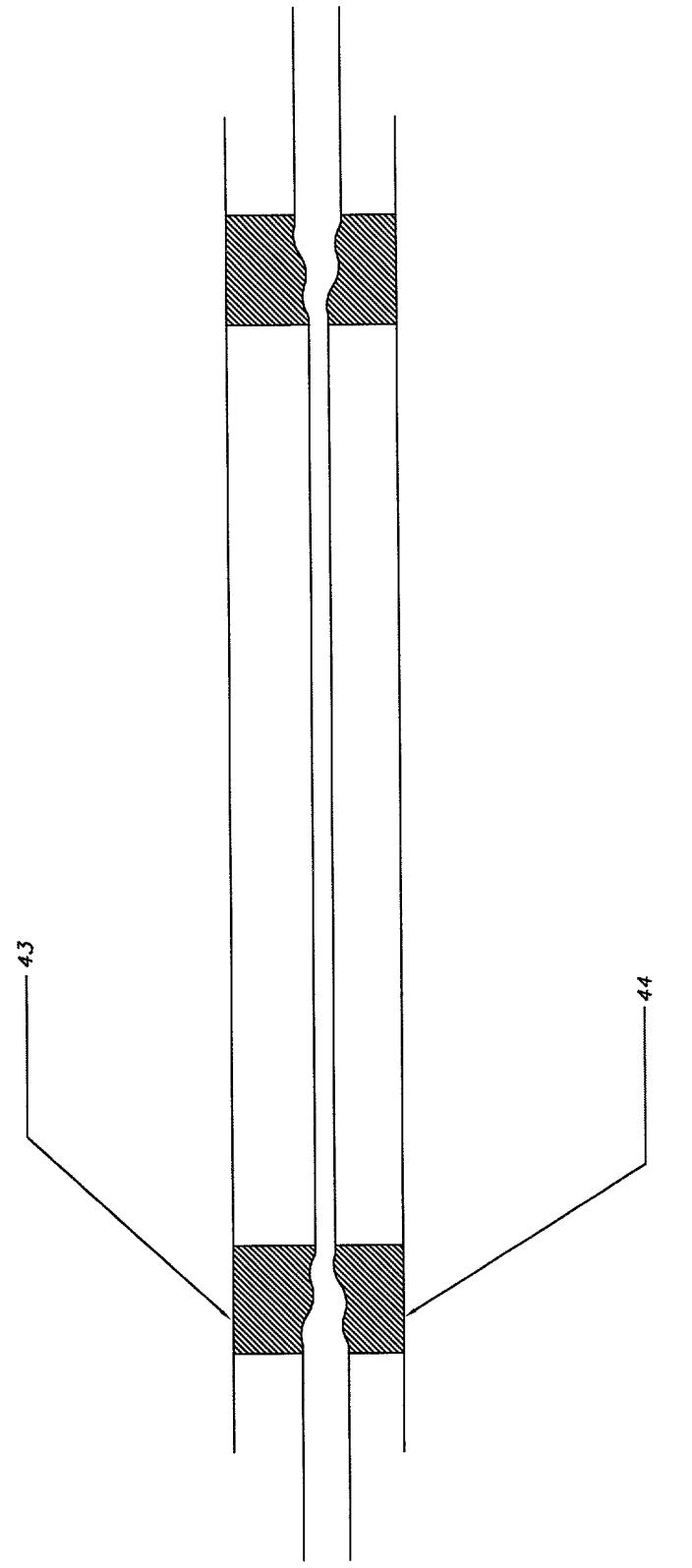


FIG 4

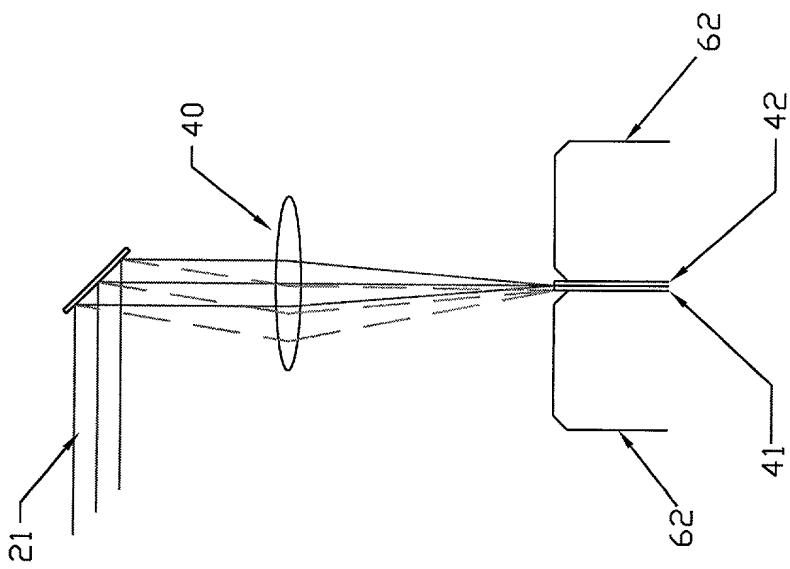


FIG. 5A

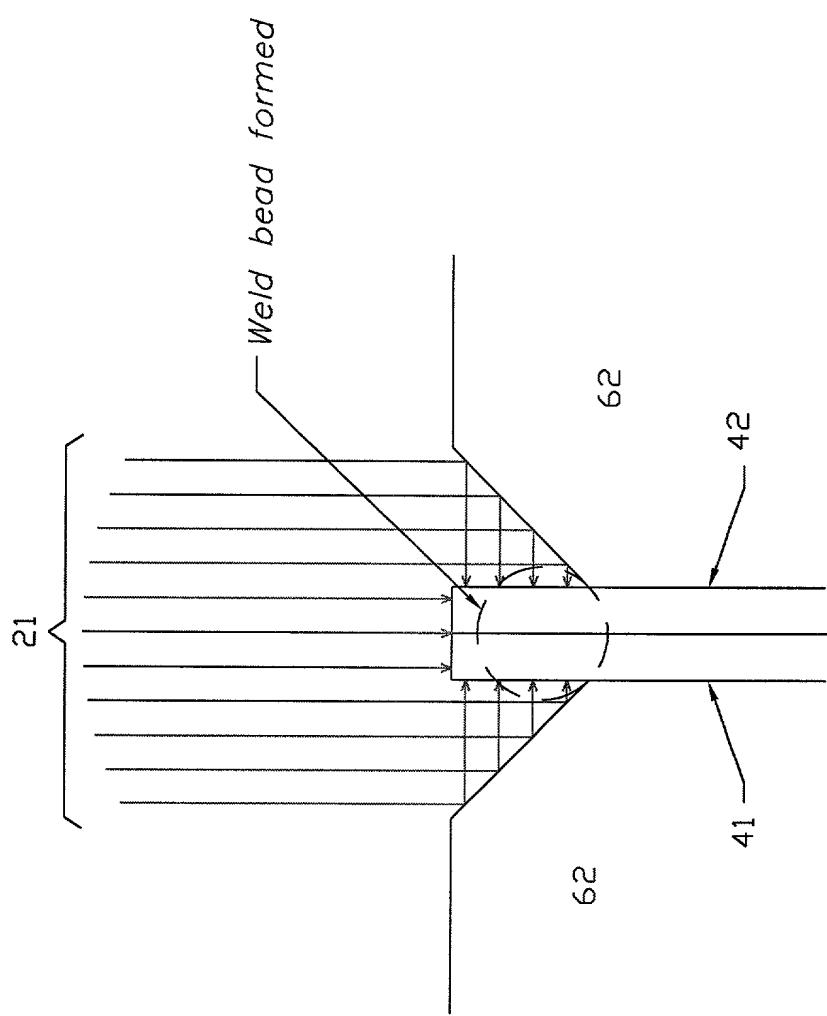


FIG. 5B

FIG. 6B

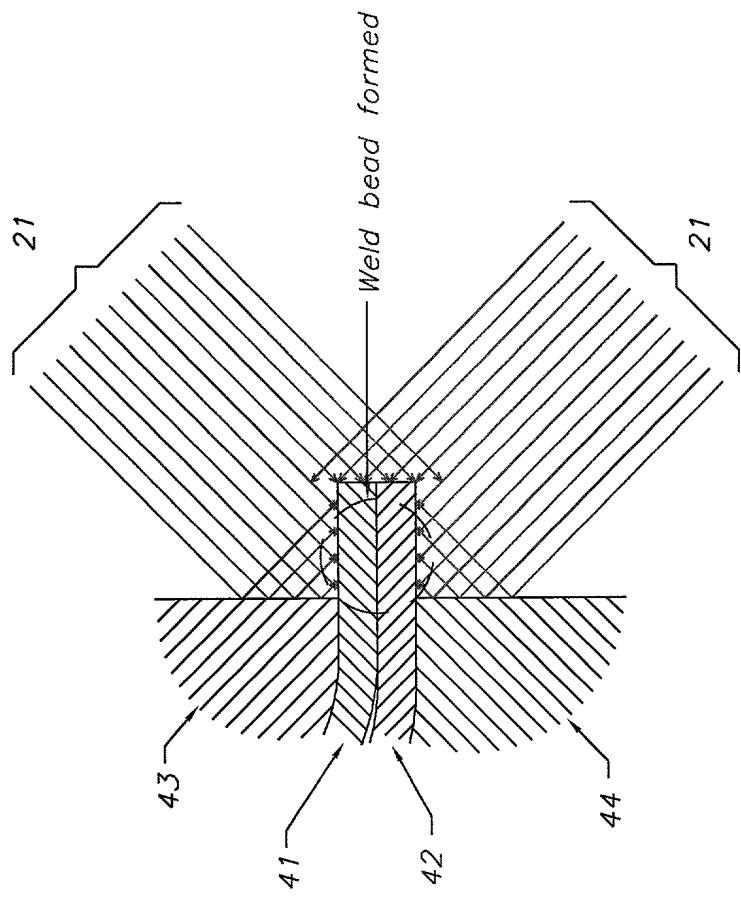
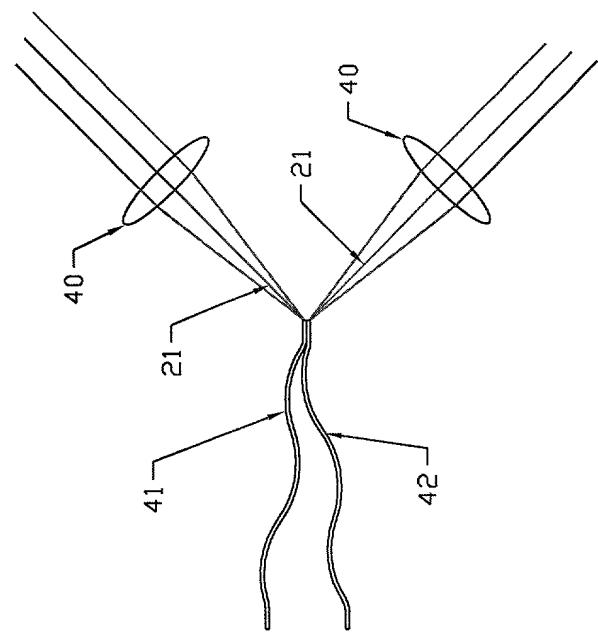


FIG. 6A



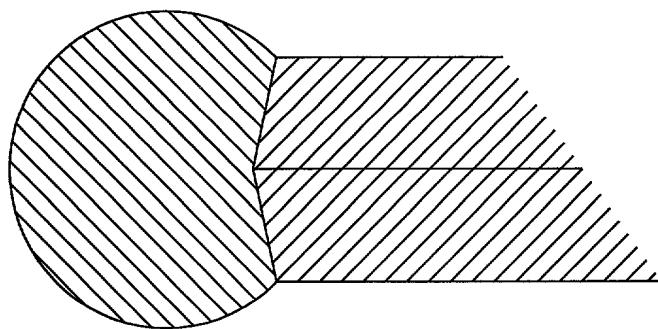


Fig. 7B

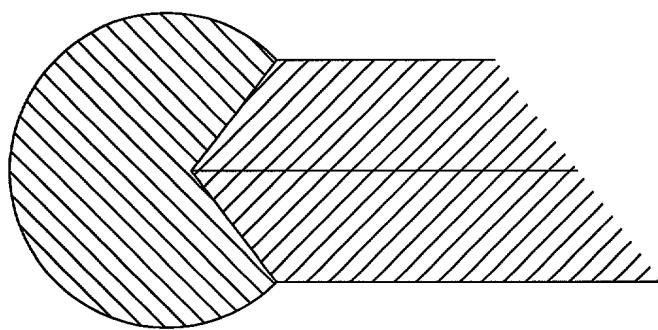


Fig. 7A

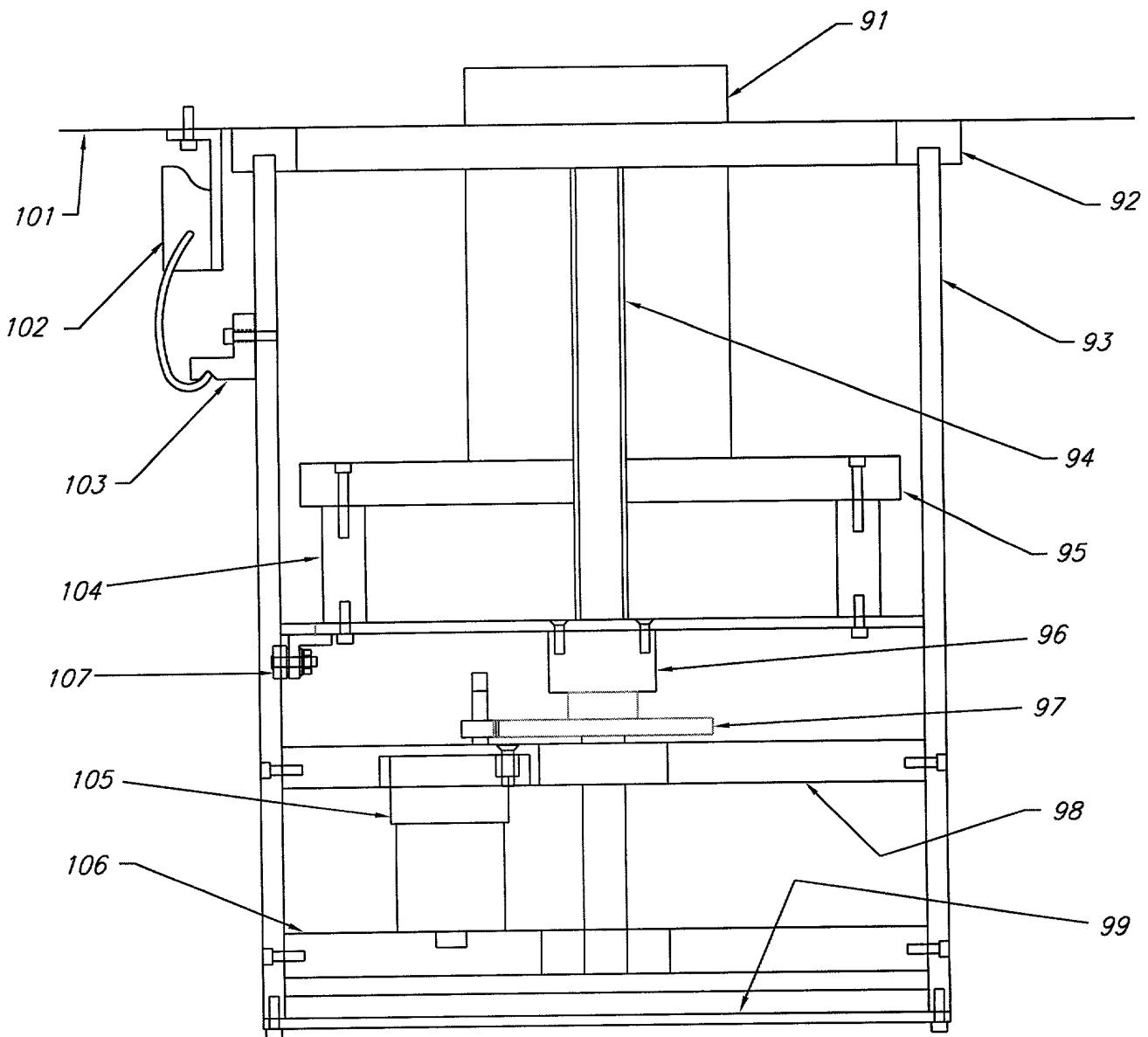
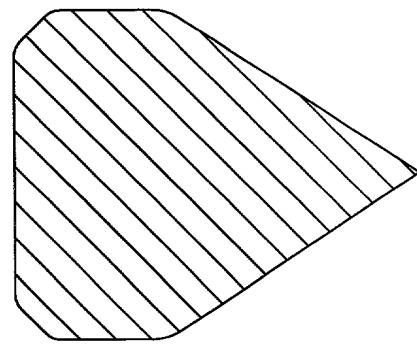
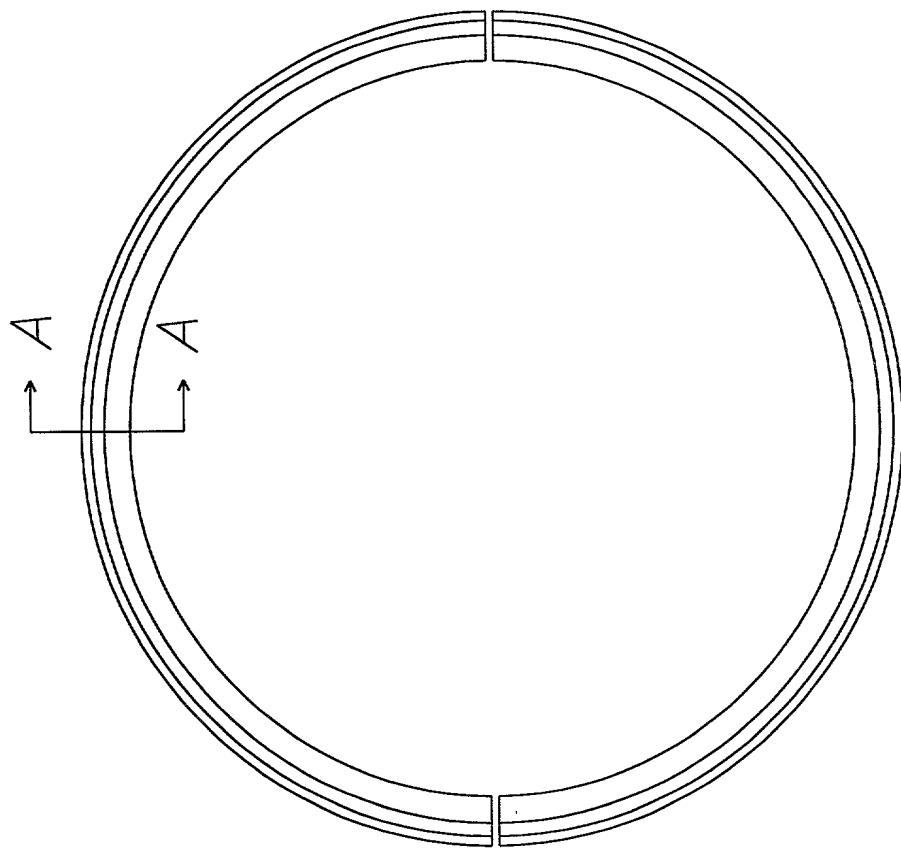


Fig. 8



Section A-A

FIG 9A

FIG 9B

*Molten beads may not run together,
forming incomplete weld*

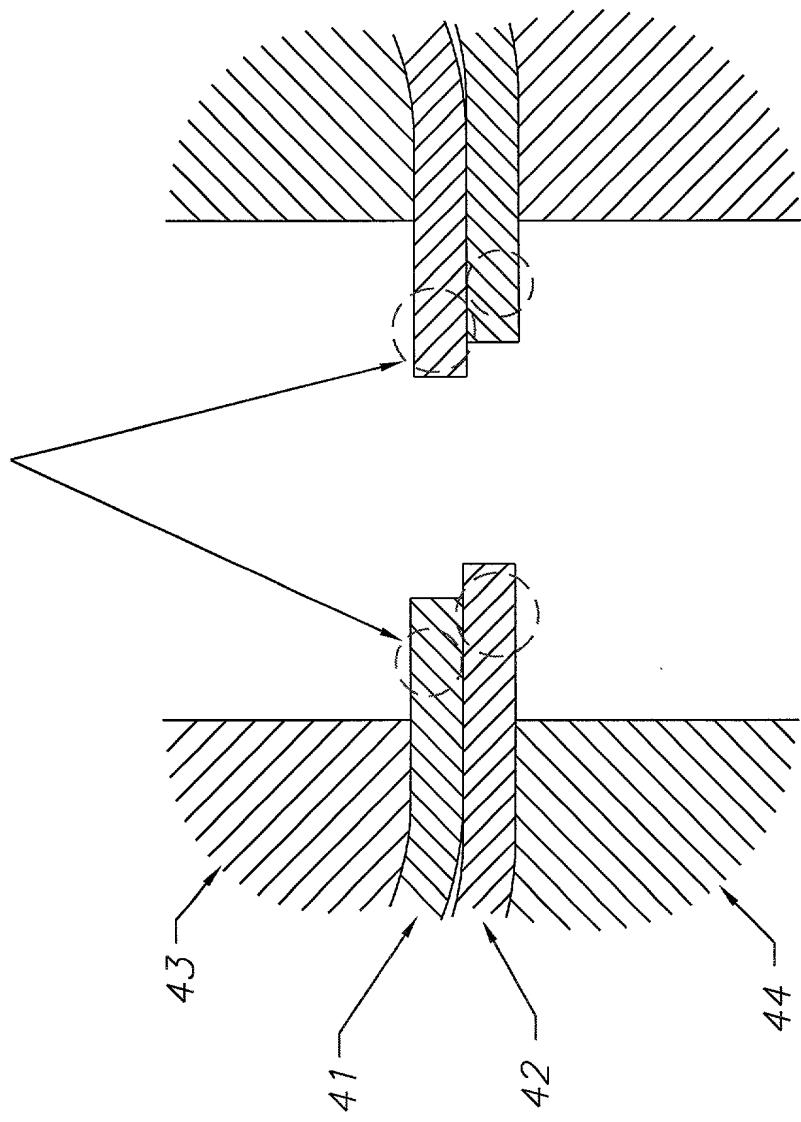


FIG 10

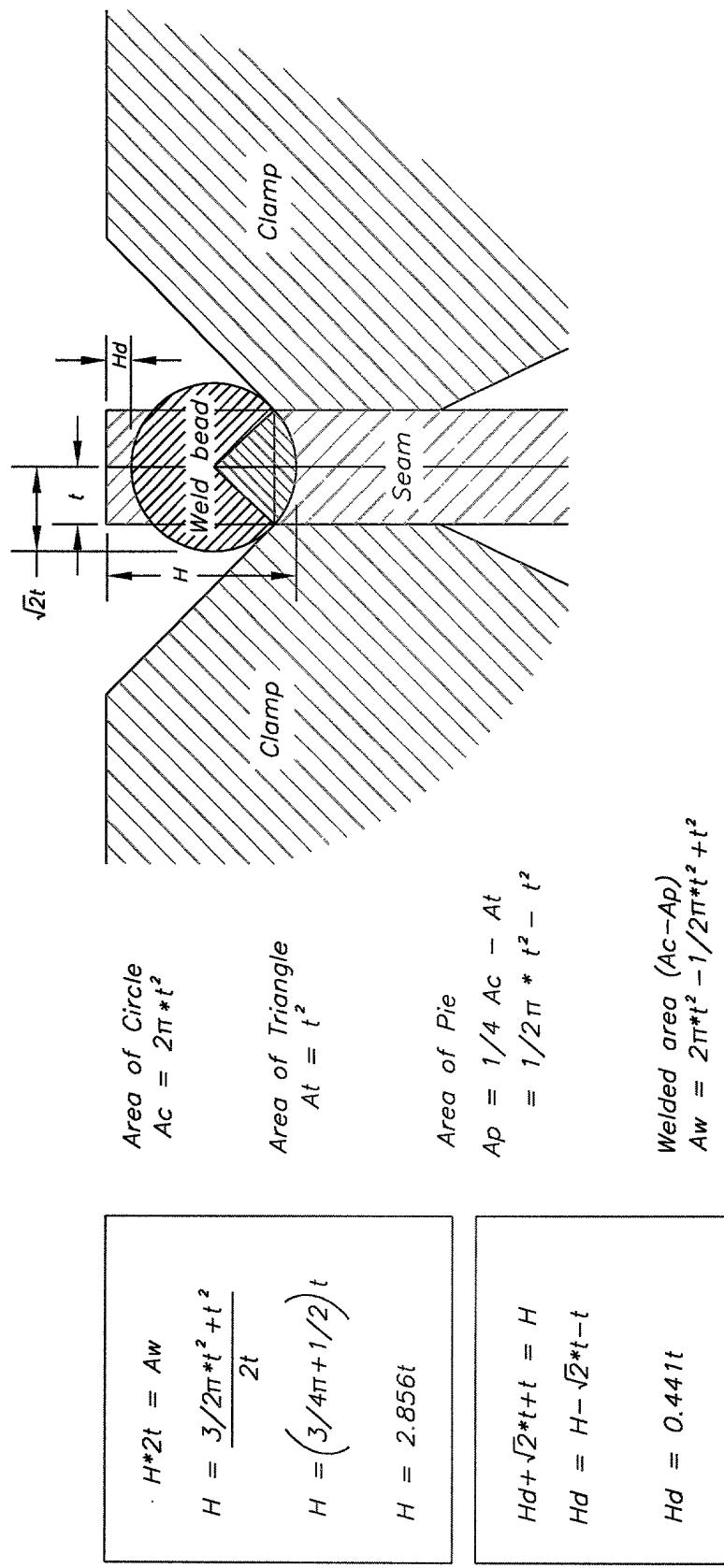


Fig. 11